

# Work Order ID 69612

Thursday, May 12, 2011 3:14:49 PM



Page 1

Item ID: D3025-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Beam

Start Date: 5/12/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

~~PRELIMINARY ISSUE~~

Reference:

Approvals:

Process Plan:

Date: 11-05-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3025	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

B11-5-17

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B1

Prog Rev: B1

2-Deburr if necessary

2024.050

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

B11-5-17

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

- inspected to PB1

Dwg only

8/10/17

(75)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Item ID: D3025-1

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Setup Start



Revision ID:

Stop



Item Name: Beam

Start Date: 5/12/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg &amp; Stock Location:

D7

0.00



Packaging

Memo

0.00

Packaging

11/15/18 (8)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/15/18

on 11/05/18

POSITIVE RECALL

EFF

AUTH

RELEASED

DATE

11/05/18

FOR ECN# 11-576

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, May 12, 2011 3:14:54 PM

Page 1

Work Order ID: 69612



Parent Item: D3025-1



Parent Item Name: Beam



Start Date: 5/12/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C01.10.26 Added Bending as per Drawing. SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			100	sf	144.0000	0.89	3.747368	3.7		
											117684		

Location

Loc Qty

Loc Code

MAT22

144

117684

144

117684

⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 69612
Description: BEAM		Part Number: D3005-1
Inspection Dwg: D3005-1 Rev: P81		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	±.004-.001	.100	X		V 1302	
.375	±.010	.377	*		V	
1.385	±.010	1.386	*		V	
1.420	±.010	1.420	X		V	
2.395	±.010	2.397	*		V	
3.00	±.030	3.003	>		V	
5.78	±.030	5.78	>		V	
.25	±.030	.251	>		V	
2.332	±.010	2.332	>		V	
4.365	±.010	4.365	>		V	
4.68	±.030	4.687	>		V	
5.80	±.030	5.802	>		V	
6.92	±.030	6.924	>		V	
7.235	±.010	7.239	>		V	
9.470	±.010	9.472	>		PROW502	
10.587	±.010	10.587	>		P	
11.705	±.010	11.708	>		P	
13.940	±.010	13.940			T	
15.057	±.010	15.057	>		T	
16.175	±.010	16.175	>		T	
18.75	±.030	18.75	>		T	
3.65	±.030	3.655	>		V	
.080	±.010	.079	>		V	

Measured by: RB	Audited by: S	Prototype Approval:
Date: 11-5-17	Date: 11/5/17	Date:

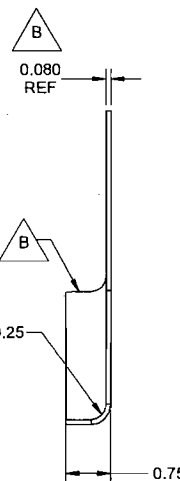
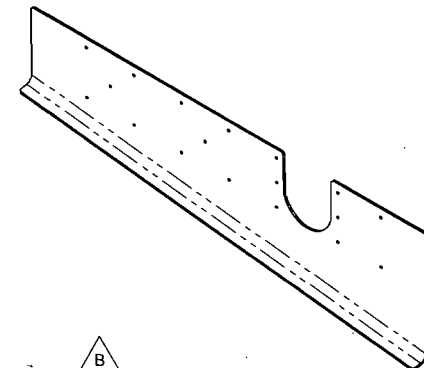
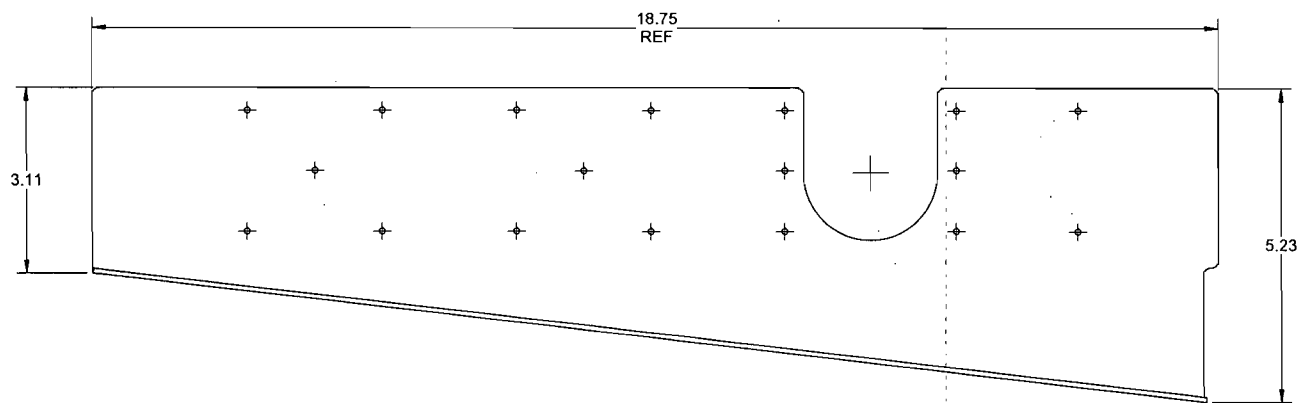
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	







#69612



**D3025-1 BEAM**

**PRELIMINARY ISSUE**

11.05.11

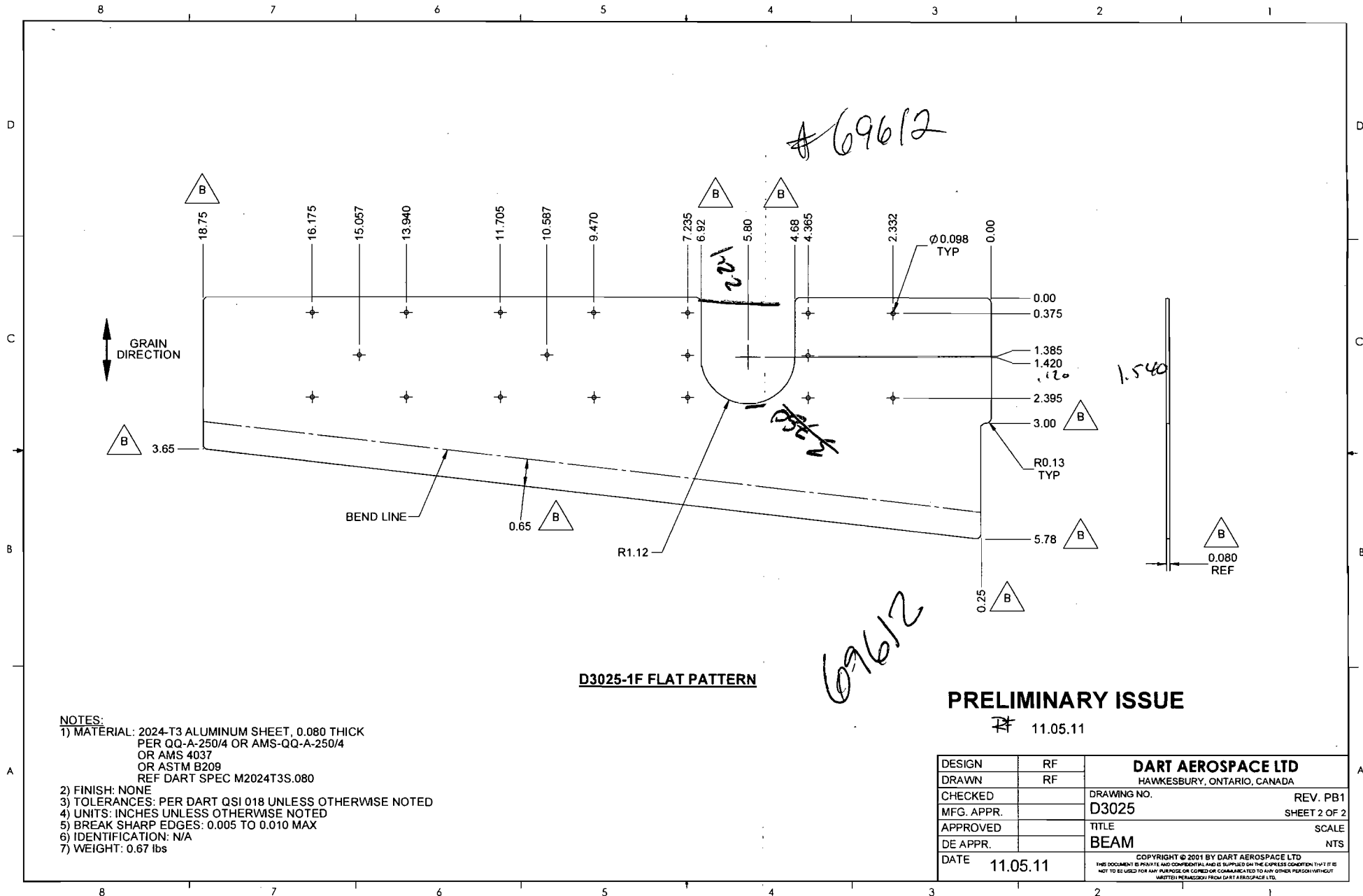
B	5.78 WAS 6.564 (ZN B2-2); 0.080 WAS 0.050 (ZN C2-1 & B1-2); DIMENSIONS CHANGED TO 2 DEC PLACES; REVERSE BEND	RF	11.05.11
A	NEW ISSUE	RF	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PB1
MFG. APPR.		<b>D3025</b>	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>BEAM</b>	NTS
DATE	11.05.11	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**NOTES:**

- 1) MATERIAL: MAKE FROM D3025-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.67 lbs

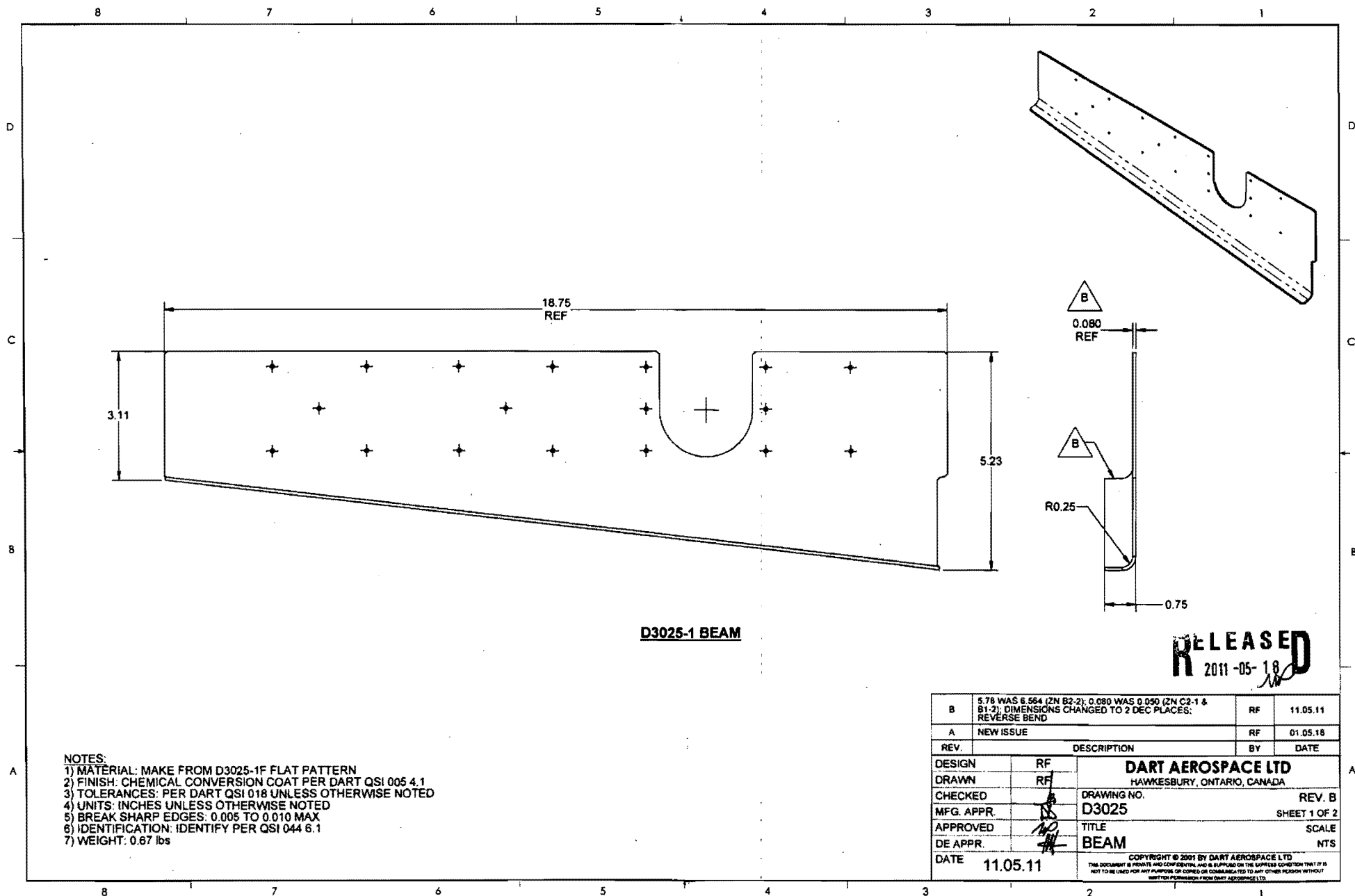
69612











# NOTES:

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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	11.05.11		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D3025**

REV. B  
SHEET 1 OF 2

TITLE  
**BEAM**

SCALE  
NTS

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